

Work Order ID 135989

135989

August 26, 2015 2:36:06 PM

Page 1

Item ID: D206-642-314 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates
 Start Date: 8/26/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/2/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: 54 20150827 Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q								
100	Document Control	0.00							DAS 02 9-89
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-314	CHG001							SEP 16 2015 SEP 16 2015
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									SEP 02 2015
120	QC4- 100% Inspect kits for completeness	0.00							DAS 02 9-89
120									
QC	Memo	0.00							
Quality Control									SEP 16 2015

B135303 RH

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

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Page 2

Item ID: D206-642-314

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/2/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-642-314

Location: _____

PPP Rev: _____

2012

DAS

02

9-89

SEP 16 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS

SEP 16 2015

Set 20150916

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.18 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-351		Manufactured	No			110	Each	0.0000	1	1			
D206-642-351		DAS 02 9-89							**	135303			DAS 6 9-89
Replacement Skidtube, Low & High Gear, Run-on Landing Wearplates Fits LH or RH													
D206-648-013		Manufactured	No			110	Each	7.0000	1	1			
D206-648-013		DAS 02 9-89							**				DAS 6 9-89
Ground Handling Wheel Modification													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				PKG013		7							
				132687		3							
				132688		4							
D2932-2		Manufactured	No			110	Each	7.0000	1	1			
D2932-2		DAS 02 9-89							**				DAS 6 9-89
Saddle RH Out, 206				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST389		2							
				129141		2							
				ST396		3							
				132374		3							
				ST403		2							
				121757		1							
				125656		1							

SEP 02 2015

B133570

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Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

D2933-2

Manufactured No

110

Each

5.0000

1

1

D2933-2
Saddle RH In, 206
02
9-89

DAS
27
9-89



Location

Loc Qty

Loc Code

ST389

1

14407

1

ST396

3

133382

3

ST403

1

125657

1

D2938-2

Manufactured No

110

Each

5.0000

1

1

D2938-2
Saddle RH Out, 206
02
9-89

DAS
27
9-89



Location

Loc Qty

Loc Code

ST395

4

133521

3

15333

1

ST403

1

125658

1

D2939-2

Manufactured No

110

Each

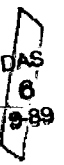
1.0000

1

1

D2939-2
Saddle RH In, 206
02
9-89

DAS
27
9-89



Location

Loc Qty

Loc Code

ST403

1

125659

1

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Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

AN3-41A

Purchased No

110

Each

570.0000

8

8

AN3-41A

DAS
02
9-89

**

DAS
27
9-89

Bolt

Location

Loc Qty

Loc Code

FG

20

122416

20

ST338a

550

123355

550

D2652

Manufactured No

110

Each

408.0000

16

16

D2652

DAS
02
9-89

**

DAS
27
SEP 8 2015

Bushing

Location

Loc Qty

Loc Code

FG

45

31985

45

ST009

321

129993

17

134494

4

135573

300

ST012a

42

123711

32

124422

2

8905

8

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Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

1,207.000

8

8

MS21042L3

Nut

DAS

02

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

384

M130922

384

GA

237

M131317

237

ST305

586

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

19

M132930

485

NAS1149D0363J

Purchased

No

110

Each

1,857.000

8

8

NAS1149D0363J

Washer

DAS

02

9-89

DAS
6
9-89
SEP 27 2015

Location

Loc Qty

Loc Code

CA

246

m130799

246

GA

302

m130799

302

ST269

1309

m126319

7

m131618

1

m132317

108

m132677

193

m133031

1000

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Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

AN5-10A

Purchased

No

110

Each

84.0000

4

4

AN5-10A **DAS**

BOLT

02

9-89

6

9-89

Location

Loc Qty

Loc Code

GA

51

122800

51

ST338

33

m132803

33

AN5-12A

Purchased

No

110

Each

62.0000

4

4

AN5-12A **DAS**

Bolt

02

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST299A

25

M131957

25

ST338

37

M132189

37

AN5-11A

Purchased

No

110

Each

22.0000

8

8

AN5-11A **DAS**

BOLT

02

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST299A

20

M126105

1

M132189

19

ST338

2

M132551

2

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Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

110

Each

1,029.000

8

8

NAS1149D0563.J

Washer

**DAS
02
9-89**

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

801

m130799

63

m132035

55

m132256

83

m132677

600

ST269

156

m128257

156

ST271

19

m131026

19

**DAS
27
9-89**

**DAS
6
9-89**

AN4-6A

Purchased

No

110

Each

649.0000

12

12

AN4-6A

BOLT

**DAS
02
9-89**

Location

Loc Qty

Loc Code

CA

143

M128403

43

M130851

100

ST345

506

M128403

8

M131153

498

**DAS
27
9-89**

**DAS
6
9-89**

SEP 02 2015

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Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

2,652.000

24

24

NAS1149D0463.J

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M132677

1000

ST269

1611

M129682

86

M130799

371

M132035

1029

M132317

125

**

DAS

27

9-89

MS21042L4

Purchased

No

110

Each

2,508.000

12

12

MS21042L 4

Locknut

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

124

m127813

124

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

2212

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2032

**

DAS

27

9-89

SEP 02 2015

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Picklist Print

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Page 8

Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110

Each

9.0000

1

1

D3407-043 **DAS**
02

Tow Ring

9-89

DAS

27

9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

st530

9

132733

9

D3456-1

Manufactured No

110

Each

76.0000

1

1

D3456-1 **DAS**

02

Washer

9-89

DAS

27

9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST038A

66

134407

66

ST051A

3

128456

3

D3457-1

Manufactured No

110

Each

18.0000

2

2

D3457-1 **DAS**

02

Washer

9-89

136442x2

DAS

27

9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

10

32409

10

ST040

8

127393

8

SEP 02 2015

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Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,004.000

1

1

MS21043-4

DAS
02
9-89

Nut

**

DAS
27
9-89

DAS
8
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

187

m128798

187

ST273A

300

m132803

300

ST304

477

m128818

39

m131697

9

m132382

4

m132536

125

m133031

300

AN4C5A

Purchased

No

110

Each

24.0000

1

1

AN4C5A

DAS
02
9-89

Bolt

**

DAS
27
9-89

DAS
8
9-89

Location

Loc Qty

Loc Code

FP001

5

131677

5

ST345

19

m132857

19

NAS1149C0463R

Purchased

No

110

Each

234.0000

1

1

NAS1149C0463R

Washer

DAS
02
9-89

**

DAS
27
9-89

DAS
8
9-89

Location

Loc Qty

Loc Code

FP001

77

m127306

77

ST271

157

m128491

157

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Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110

Each

10.0000

1

1

D3413-1

O-Ring

DAS
02
9-89

Location

Loc Qty

Loc Code

st530

10

125157

3

129085

1

132500

1

133922

5

**

DAS
27
9-89

DAS
02
9-89

D2712

Manufactured No

110

Each

135.0000

10

10

D2712

Set Screw

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

55

29962

55

ST009

10

89929

10

ST012a

70

130024

70

**

DAS
27
9-89

DAS
02
9-89

D2934

Manufactured No

110

Each

15.0000

2

2

D2934

Saddle Spacer

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

6

31929

6

ST014

9

132439

9

**

DAS
27
9-89

DAS
02
9-89

SEP 02 2015

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Work Order ID: 135989

135989

Parent Item: D206-642-314

D206-642-314

Parent Item Name: Skidtube RH, Low & High Gear with Run-on Landing Wearplates

Start Date: 8/26/2015

Required Date: 9/2/2015

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

10.0000

2

2

D2935

Saddle Spacer

DAS

02

9-8

27

9-89

SEP 02 2015

Location

Loc Qty

Loc Code

FG

6

31793

6

ST014

2

115157

2

ST025A

2

131107

2

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-36A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN980C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4361-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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